

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011723**Date Inspected:** 26-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

CB6

This QA Inspector along with Caltrans QA Mr. Manikandan performed Joint Inspection for the Cross Beam 6 for the Gap and Offset at the following locations.

East Bound Vertical Position at PP 44

West Bound Vertical Position at PP 44

East Bound Vertical Position at PP 45

West Bound Vertical Position at PP 45

East Bound Vertical Position at PP 46

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West Bound Vertical Position at PP 46

East Bound Bottom Panel at PP 44 to PP 45

West Bound Bottom Panel at PP 44 to PP 45

East Bound Bottom Panel at PP 45 to PP 46

West Bound Deck Panel at PP 45 to PP 46

East Bound Deck Panel at PP 44 to PP 45

West Bound Deck Panel at PP 44 to PP 45

East Bound Deck Panel at PP 45 to PP 46

West Bound Deck Panel at PP 45 to PP 46

The measured readings were data recorded in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 6BW to 6CW (Joint Survey with ABF)

This QA Inspector performed Joint Inspection along with ABF for the Skin Flatness by 5000mm String line, 630mm and 600mm at B1, B2, B3 and B4 locations and the following reading were recorded.

At B1 when checked with 600/630 Straight Edge observed 2mm deflection.

At B2 when checked with 600/630 Straight Edge observed 3mm/3mm at 4500mm from PP 44 deflection.

At B3 when checked with 600/630 Straight Edge observed 3mm/3mm at 4000mm from PP 44 deflection.

At B4 when checked with 600/630 Straight Edge observed 5mm/4mm at 4000mm from PP 44 deflection.

When checked with 5000mm String line

At B2 location found 6mm deflection.

At B3 location found 11mm deflection.

At B4 location found 9mm deflection.

Segment 6CW

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This QA Inspector measured the Vertical Offset for Side Panel T-Ribs to T-Ribs for Segment 6CW after bolting 8 bolts on either side of the T-Ribs and the reading were recorded at PP 44 to 44.5, PP 45 to 45.5 and PP 45.5 to PP 46. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review. The readings out of tolerances as per AFB RFI No. 002004 R0 Dated Dec 17, 2009 were added in the punch list.

Segment 6BW

This QA Inspector measured the Vertical Offset for Side Panel T-Ribs to T-Ribs for Segment 6BW after bolting the T-Ribs and the reading were recorded at PP 38 to 38.5, PP 39 to 39.5 and PP 39.5 to PP 40. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review. The readings out of tolerances as per AFB RFI No. 002004 R0 Dated Dec 17, 2009 were added in the punch list.

Segment 6AW

This QA Inspector along with Caltrans QA Mr. Manikandan performed Joint Inspection for the Deck Panel Diaphragm to Deck Panel at PP 38 for Segment 6AW East and West side of the Diaphragm and the measured reading were submitter to Task Leader and Engineer for review.

Note: The measurement was taken by 600mm carpenter square.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
